

Date: Thursday, 24/04/2008 3:29:55 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SIDE DOOR LATCH MODIFICATION KIT
Job Number : 38783	
Estimate Number : 11544	
P.O. Number :	Part Number : D350589011
This Issue : 24/04/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : N/A
Previous Run : 37938	Material :
Written By :	Due Date : 02/05/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JD 08.4.24</u>	
Comment : Est. F02.08.29 Removed D2587 Plug KJ ALL AT CHANGE 002	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type label as per PPP D350-589-011 CHG002

JD 08.4.28
 506/05/01

2.0	D2237	Striker Plate
-----	-------	---------------

**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 30.0000 Each(s)

Striker Plate

Pick:

Qty	Part Number	Description	Batch
* 3	D2237	Striker Plate	36847

SD

3.0	D2583	Latch Bracket
-----	-------	---------------

**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 30.0000 Each(s)

Latch Bracket

Pick:

Qty	Part Number	Description	Batch
* 3	D2583	Latch Bracket	38032

SD

4.0	D2585	Mounting Channel
-----	-------	------------------

**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 30.0000 Each(s)

Latch Clamp

Pick:

Qty	Part Number	Description	Batch
3	D2585	Latch Clamp	37433

B 38813 5X 6/8/01

8/4/28

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 24/04/2008 3:29:56 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR LATCH MODIFICATION KIT

Job Number: 38783

Part Number: D350589011

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2586 Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total: 30.0000 Each(s)

Door Latch

Pick:

Qty Part Number Description Batch
3 D2586 Door Latch

Batch

36884 (18)

38174 (12x)

SP

6.0 D2589 Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Keys, Key Chain

Pick:

Qty Part Number Description Batch
1 D2589 Keys, Key Chain

Batch

31887 (9x)

38814

9273 (2x)

SP

7.0 D2587 Door Slug, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Door Plug

Batch:

36044 (2x)

38678 4x

SP

8.0 MS20470AD45 Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch
6 MS20470AD4-5 Rivet

104136

SP

9.0 AN960JD10 Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 30.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch
3 AN960JD10 Washer

107715

8/4/28

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 24/04/2008 3:29:56 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR LATCH MODIFICATION KIT

Job Number: 38783

Part Number: D350589011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 30.0000 Each(s)

Screw

Pick:

Qty Part Number

Description

Batch

3

MS27039-1-15

Screw

106576 (34)

106903 (27x)

SP

11.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 30.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

3

MS21042L3

Nut (or -3)

M107643

8/4/28

SD

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50805/01 (10)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per QSI 014

F 28/5/01 (10)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/05

Job Completion



MF 08-05-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 38283